



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D3953-7**

**Job Sheet 170282**



**Part No:** D3953-7

**Job Qty:** 40 ea

**Part Name:** Spring Spacer



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 1/12/18

**Job Tracking No:**

**Due Date:** 1/26/18

**Created By:** Mario Poulin

**Type:** Stock

**Description:**

**Note:** DWG REV C IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revC DD 10.03.02 verified by:EC

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign off    |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                    |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation | 40 Ea  |            | 1/25/18  | 0.00      | 0.00    | Start Up Machining-2  |           | DAS 23      |
| 100   | Hardinge           | 40 pcs |            | 1/26/18  | 0.00      | 1.78    | Hardinge              |           | 9-89        |
| 120   | QC                 | 40 pcs |            | 1/26/18  | 0.00      | 0.00    | QC8                   |           | mk 18/01/30 |
| 130   | Packaging          | 40 pcs |            | 1/26/18  | 0.00      | 0.00    | Packaging3-2          |           | 5060        |
| 140   | QC21-SA            | 40 Ea  |            | 1/26/18  | 0.00      | 0.00    | QC21                  |           | mk 18/02/01 |

Part Op Descriptions: 100 - TURN AS PER FOLIO FA854 & DWG

DAS  
21  
9-89  
FEB 02 2018

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------|----------|-----------|-----------|---------|
| 90-Start up Operation | MDELRINR0.750  | 2        | 41        | 0         | 0       |

### Part Specifications

| Spec No | Description       | Target/Tolerance               | Limits         | Type     | Special Comments |
|---------|-------------------|--------------------------------|----------------|----------|------------------|
| 1       | Gas Spring Spacer | 0.630Inches ± 0.030            | 0.660<br>0.600 | Diameter |                  |
| 2       | Gas Spring Spacer | 0.257Inches + 0.006<br>- 0.001 | 0.263<br>0.256 | Diameter |                  |
| 3       | Gas Spring Spacer | 0.370Inches + 0.000<br>- 0.030 | 0.370<br>0.340 |          |                  |

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                              |                                               |                                        |                                     |                                              |                                      |  |  |
|--------------------------------------------------------------|-----------------------------------------------|----------------------------------------|-------------------------------------|----------------------------------------------|--------------------------------------|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | DISPOSITION                                   | AGAINST DEPARTMENT/PROCESS             |                                     |                                              |                                      |  |  |
|                                                              | Rework <input type="checkbox"/>               | Skid-tube <input type="checkbox"/>     | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |  |  |
|                                                              | Scrap <input type="checkbox"/>                | Machining <input type="checkbox"/>     | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |  |  |
|                                                              | Use-as-is <input type="checkbox"/>            | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |  |  |
|                                                              | Suspected Unapproved <input type="checkbox"/> | Large Fab <input type="checkbox"/>     | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>            |                                      |  |  |

QTY Effective : \_\_\_\_\_

MRB (QSI042) Approval

|  |             |                                              |
|--|-------------|----------------------------------------------|
|  | Disposition | Completed By                                 |
|  |             | Lead hand / Supervisor Approval Verification |
|  |             | QC / QA Coordinator Approval                 |

### FAULT CATEGORY

|        |                                                            |                                                |                                               |
|--------|------------------------------------------------------------|------------------------------------------------|-----------------------------------------------|
| ntric  | <input type="checkbox"/> Temperature/Cure                  | <input type="checkbox"/> Power Loss/Surge      | <input type="checkbox"/> Positioned Wrong     |
|        | <input type="checkbox"/> Set-up                            | <input type="checkbox"/> Folio/Program         | <input type="checkbox"/> Outside Dimensions   |
|        | <input type="checkbox"/> BOM/Route                         | <input type="checkbox"/> Grain                 | <input type="checkbox"/> Over/Under tolerance |
|        | <input type="checkbox"/> Broken/Damage/Defect              | <input type="checkbox"/> Weld                  | <input type="checkbox"/> Part Incorrect       |
| e/Wave | <input type="checkbox"/> Inspection Incomplete/Unqualified | <input type="checkbox"/> Wrong Stock Pulled    | <input type="checkbox"/> Part Lost/Missing    |
|        | <input type="checkbox"/> Contamination                     | <input type="checkbox"/> Out of Sequence       | <input type="checkbox"/> Part Moved           |
|        | <input type="checkbox"/> Countersink                       | <input type="checkbox"/> Off-set               | <input type="checkbox"/> Drawing              |
|        | <input type="checkbox"/> Cut Too Short                     | <input type="checkbox"/> Mislabeled            | <input type="checkbox"/> Finish               |
| be     | <input type="checkbox"/> Instructions Incomplete/Unclear   | <input type="checkbox"/> Fit/Function          | <input type="checkbox"/> Misread              |
|        | <input type="checkbox"/> Drill Holes                       | <input type="checkbox"/> Misaligned/off center | <input type="checkbox"/> Turning Sequence     |

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Spring Spacer

PART NO: D3953-7

Original Serial #: S036671

Revision:

Operation: Start up Operation 01/29/18

Change No: Job No: 170282



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## Inventory

| Operation Number                                                               | Operation  | Serial Number | Job    | Master Unit Number | Quantity | Weight | Original Serial Number | Location | Container | Status | Added     | Special Comments | Label | Supplier | Change No | Inventory Type |
|--------------------------------------------------------------------------------|------------|---------------|--------|--------------------|----------|--------|------------------------|----------|-----------|--------|-----------|------------------|-------|----------|-----------|----------------|
| <b>Part Number: D3953-7 Revision: Spring Spacer</b>                            |            |               |        |                    |          |        |                        |          |           |        |           |                  |       |          |           |                |
| 140                                                                            | QC21-SA    | S036671       | 170282 |                    | 40 Ea    | 0      | S036671                | QC21     |           | Stock  | 1/29/2018 | *                |       |          |           | False          |
| <b>Operation Totals:</b>                                                       |            | 1             |        |                    | 40       | 0      |                        |          |           |        |           |                  |       |          |           |                |
| <b>Part Totals:</b>                                                            |            | 1             |        |                    | 40       | 0      |                        |          |           |        |           |                  |       |          |           |                |
| <b>Part Number: MDELRRN0.750 Revision: Delrin Round Bar 0.75" Color: Black</b> |            |               |        |                    |          |        |                        |          |           |        |           |                  |       |          |           |                |
| 100                                                                            | Receive Ft | S036665       | 170282 |                    | 2 ft     | 0      | po34713                | MAT018   |           | Stock  | 1/29/2018 | *                |       |          |           | False          |
| <b>Operation Totals:</b>                                                       |            | 1             |        |                    | 2        | 0      |                        |          |           |        |           |                  |       |          |           |                |
| <b>Part Totals:</b>                                                            |            | 1             |        |                    | 2        | 0      |                        |          |           |        |           |                  |       |          |           |                |
| <b>Totals:</b>                                                                 |            | 2             |        |                    | 42       | 0      |                        |          |           |        |           |                  |       |          |           |                |

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